

Friday, April 04, 2014 1:59:34 PM

1 15966

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Top Strap Attach Bracket

Stop *NS2*

Start Date: 4/15/14 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 4/15/14 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-04-10

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D4004	B	

100

0.00

100

BAND SAW

0.00

Bandsaw

Memo

Jeaspa Bandsaw

1-Cut D3033-144 extrusion to length per D4004-11 detail of dwg D4004

Ensure cut is started at correct place per dwg

Batch:

2-Deburr

105

0.00

105

Small Fab

Memo

0.00

Small Fab

Drill and c'sink holes as per dwg and trim part to lenght as required.

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Item ID: D4004-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Top Strap Attach Bracket

Start Date: 4/15/14 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 4/15/14 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

DAS
27

9-89

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Item ID: D4004-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Top Strap Attach Bracket

Start Date: 4/15/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/15/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: **8T24B**

0.00

140

Packaging

Memo

0.00

Packaging

4X**14-5-16****DAS
26
9-89**

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

14/5/20 JJ**14-5-16**

Picklist Print

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Work Order ID: 115966

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Parent Item: D4004-11

D4004-11

Parent Item Name: Top Strap Attach Bracket

Start Date: 4/15/14

Required Date: 4/15/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD IPP Rev:B
10.05.17 as per ECN10-562 DD verf:EC IPP Rev:C 12.03.07
as per dwg rev.b DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
40456-11-144		Purchased		No		100	f	20.0000	0.41	1.726316			

40456-11-144

**

Seat Track

Location

Loc Qty

Loc Code

ST

20

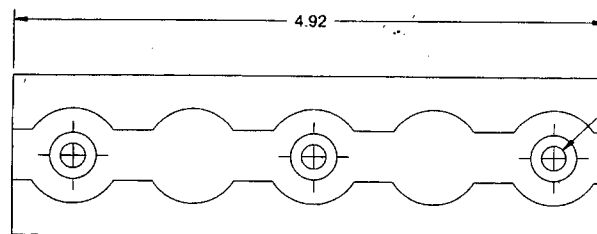
108482

20

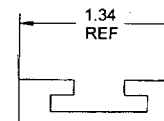
1.72

MH 14/04/2014

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-11	JCA-M47-2-11



DRILL $\varnothing 0.204$ (#6 DRILL)
CONCENTRIC WITH SEAT TRACK
CSK $\varnothing 0.385 \times 100^\circ$
3 PL



D4004-11 TOP STRAP ATTACH BRACKET

NOTES:

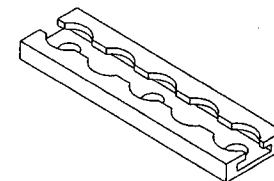
- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144
OR BROWNLINE P/N 20276-144-0-0
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.14 lbs

DESIGN	BC
DRAWN	BC
CHECKED	BC
MFG. APPR.	BC
APPROVED	BC
DE APPR.	BC
DATE	12.02.27

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4004** REV. B
SHEET 11 OF 11
TITLE **SIDE RESTRAINT** SCALE NTS

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115966-MCS
14-04-10

RELEASED
2012-03-02